

# Work Order ID 84892

**\*84892\***

Page 1

May-29-12 2:47:18 PM

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/05/29* Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2906

Rev B

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

*003 per ECN 12-599*

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

*> CF 12-6-11*



*KC*

*> SAD 12-06-11*

*> CF 12-6-11*

W/O: 84892		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D209-669-013 PAR #: \_\_\_\_\_ Fault Category: STEADY STATE NCR: Yes No DQA: 10/2 Date: 12/07/27  
 Resolution: \_\_\_\_\_ Disposition: USE AS IS QA: N/C Closed: ck Date: 12/7/27

NCR: 12-1626		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/18	140	Tube is over bent. Swd: 2.20 APT= 1.625 RC?	GP 12/6/18	Acceptable.	 12-618	SAD 12-06-18	GP 12/6/18	 12/4/18

NOTE: Date & initial all entries

# Work Order ID 84892

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Item ID: D209-669-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC3- Inspect Part Finish

0.00

\*120\*

627

QC

Memo

0.00

Quality Control

① SAD 12-06-12

130

0.00

\*130\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M121409

Sikaflex expire date: 13-9-12

Start Time: 7:50 Date: 12-6-12

Fin Time: 11:00 Date: 12-07-09

pick:

Qty P/N description

1 D2926-3

Web

BAN

84950

1 CF 12-6-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Dec-12	120	Change Qc3 to Qc7					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*84892\***

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Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
<b>*140*</b>	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150		0.00							
<b>*150*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160		0.00							
<b>*160*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

*[Handwritten signature]*

*12-6-13*

*BE12-06-18*

*- Dec 12/07/05*

*- Dec 12/07/09*

*1 0 BE12/07/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D209-669-043

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00

\*170\*

Large Fab

Skidtubes

Memo

0.00

Skidtubes

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

DC 12/06/09

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Memo

0.00

Quality Control

5/20/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200 Pressure Wash per QSI005 4.3

0.00

**\*200\***

HandFinish

Memo

0.00

Hand Finishing

1 2/6 12-79

210 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*210\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15  
320°F  
8:45

0.00

1X 12/07/10

220 QC3- Inspect Part Finish

0.00

**\*220\***

QC

Quality Control

Memo

0.00

12/07/10

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 <u>12/130</u> Sikaflex expire date: <u>14/03</u>								
	2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906								
	3-Inspect for foreign object per QSI 024								
	4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 <u>12/130</u> Sikaflex expire date: <u>14/03</u>								
	5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch: <u>122360</u>								

1 2 2P 12/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84892

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May-29-12 2:47:18 PM

Item ID: D209-669-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
*240*									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
250	Packaging	0.00							
*250*									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD209-669-043								
	Location: _____								
	PPP Rev: <u>PPP 84921</u>								
260	QC21- Final Inspection - Work Order Release	0.00							
*260*									
QC	Memo	0.00							
Quality Control									

6/12/12 (1)

ML5 12/07/12

W 12/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 84892

**\*84892\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD  
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 <b>*D4202-1*</b> Spacer		Manufactured	No				Each	81.0000		19			
									**	12/12/05			
									(19)				
				<u>Location</u>	<u>B83263</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
				LG		5							
					77727	5							
				LG002		76							
					78806	6							
					79810	70							
D2500-1-190 <b>*D2500-1-190*</b> Ext'n -1" Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**	CF 12-6-11			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				HALL		91							
					74777	14							
					80061	77							
D2926-3 <b>*D2926-3*</b> Web		Manufactured	No			110	Each	0.0000	1	1			
									**	CF 12-6-12			
				B84950									
D2855 <b>*D2855*</b> Cap		Manufactured	No			230	Each	21.0000	2	2			
									**	2 (28) 12/07/11			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FP002	84952	21							
					65519	2							
					73347	16							
					75074	3							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84892

\*84892\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A	Purchased	No	230	Each	1,090.000	4	4	
<b>*AN3-5A*</b>								<b>**</b>
Bolt								Y (2P) 12/07/11

Location	Loc Qty	Loc Code
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187 ✓	500	
121185	189	

AN960JD10L	<del>✗</del> NAS1149D0332J ✓	Purchased	No	230	Each	0.0000	4	4	
<b>*AN960JD10I *</b>								<b>**</b>	
Washer									4 (2P) 12/07/11

12104 ✓

ALS7-1032-130		Purchased	No	230	Each	2,136.000	44	44	
<b>*AI S7-1032-130*</b>								<b>**</b>	
Insert									44 (5P) 12/07/11

Location	Loc Qty	Loc Code
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444 ✓	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

\*AN3C4A\*

BOLT

\*\*

44

2P

12/07/11

Location

Loc Qty

Loc Code

ST350

122151✓

1458

120187

57

120521

28

120769

38

121205

1000

121556

335

AN960C10L

~~X~~ NAS1149C0332  
R

Purchased

No

230

Each

0.0000

44

44

\*AN960C10I \*

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

\*D2594-3\*

O-Ring, 205 Skidtube

\*\*

44

2P

12/07/11

122063✓

\*\*

14

2P

12/07/11

Location

Loc Qty

Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755✓

1343

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**\*84892\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

**\*D2594-1\***

Plug, 205 Skidtube

\*\*

14

SP

12/07/11

Location

Loc Qty

Loc Code

FP001

84951✓

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

D3564-9

Manufactured No

230

Each

22.0000

1

1

**\*D3564-9\***

Wearshoe

\*\*

1

SP

12/07/11

Location

Loc Qty

Loc Code

FG

84870✓

4

76950

4

FP001

18

67590

4

69943

1

82255

13

D3564-11

Manufactured No

230

Each

8.0000

1

1

**\*D3564-11\***

Wearshoe

\*\*

1

SP

12/07/11

Location

Loc Qty

Loc Code

FG

83910✓

4

77056

4

FP001

4

80341

4

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 84892

\*84892\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5	Manufactured	No	230	Each	13.0000	1	1	
<b>*D3564-5*</b>								
Wearshoe								
					**	1	12/07/11	

Location	Loc Qty	Loc Code
FG 84869 ✓	2	
34806	2	
FP001	11	
77609	3	
82254	8	

D3566-1	Manufactured	No	230	Each	31.0000	2	2	
<b>*D3566-1*</b>								
Gasket								
					**	2	12/07/11	

Location	Loc Qty	Loc Code
FP 86240 ✓	-22	
81619	10	
FP002	53	
68924	2	
80919	3	
83898	16	

D3566-5	Manufactured	No	230	Each	21.0000	1	1	
<b>*D3566-5*</b>								
Gasket								
					**	1	12/07/11	

Location	Loc Qty	Loc Code
FP	12	
82275	12	
FP002	9	
80374	3	
82274	6	
84881 ✓		

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Page 5

W/O:		WORK ORDER CHANGES					
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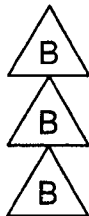
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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WITHOUT NOTICE  
WORK ORDER  
NO. 84892 M.C.S.  
12/05/29

RELEASED

07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD	
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 1 OF 3
APPROVED	120	TITLE	SCALE
DE APPR.	120	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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• NOTE: Date & initial all entries



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DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	90	D2906	SHEET 3 OF 3
APPROVED	90	TITLE	SCALE
DE APPR.	90	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
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